

Work Order ID 83953

Monday, April 30, 2012 10:59:38 AM

83953

May 25 Page 1

Item ID: D4273-042	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					
Item Name: Basket Base Assembly, RH				Stop	*NS2*
Start Date: 5/4/2012	Start Qty: 1.00	*1*	Cust Item ID:		
Required Date: 5/24/2012	Req'd Qty: 1.00	*1*	Customer:		
Reference:					

Approvals:	Process Plan: <i>mf</i>	Date: <i>12-04-30</i>	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4273	D								
D4279	B								

100 Weld per dwg A/R S.S. rod Batch: *11121602* 0.00

100

Large Fab

Large Fab

Memo 0.00

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

1x *PL 12.05.28*

2 05.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly, RH
Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/24/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

8/21/05/29

IX *Ø* *ML* *12/05/29*

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Page 3

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 Item Name: Basket Base Assembly, RH
 Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/24/2012 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: <u>1:20</u> START TIME: <u>4:00</u> OVEN TEMPERATURE: <u>0 F</u> FINISH TIME: <u>1:25</u> ***** 2nd coat if necessary ***** 2ND COAT: <u>8:10</u> START TIME: <u>4:00</u> OVEN TEMPERATURE: <u>0 F</u> FINISH TIME: <u>8:40</u>	0.00 0.00				IX	Ø		M-L 12/05/29
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				IX	Ø		M-L 12/05/30

M121134

M121134

IX Ø

IX Ø M-L 12/05/30

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83953

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/4/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 5/24/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp.
Stam

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/05/30

MF 12-05-36

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 83953

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
DWG REV.C DD verf:EC

IPP Rev:B 11.01.20 AS PER
IPP Rev:C 11.03.03 AS PER DWG REV.D DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	1,037.7169	26.195	26.195			

Location

Loc Qty

Loc Code

MAT	80.8585	
121347	80.8585	
WA	254.0001156	
119180	0.0001156	
121471	254	
WA035	702.8582641	
117197	102.9036	
117896	29.49258	
118153	76.8473	
118955	82.17	
119180	53.6958107	
119729	28.1132686	
120153	2.97557478	
120917	120.52013	
121082	14.14	
121521	192	

121738 → 26.195

D3913-1

Rib

Manufactured No

100 Each 5.0000

1 1

Location

Loc Qty

Loc Code

WA	1	
74145	0	
80790	1	
WA006	4	
81195	2	
81437	2	

B82918 → ①

Pl 12-05-22

Pl 12-05-22

W/O:		WORK ORDER CHANGES					
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Work Order ID: 83953

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No 100 Each 7.0000

1 Shp 12-05-17

Rib

Location	Loc Qty	Loc Code
WA	3	
69160	0	
74144	0	
81443	3	
WA006	4	
69160	1	
82921	3	B82920

D3913-9 Manufactured No 100 Each 11.0000

1 Shp 12-05-17

Hinge Rib

Location	Loc Qty	Loc Code
WA	4	
81200	4	
WA006	7	
70138	1	
81199	4	
83227	2	

D3916-5 Manufactured No 100 Each 4.0000

3 Shp 12-05-17

Light Rib

Location	Loc Qty	Loc Code
WA	4	
77142	4	

D4017-7 Manufactured No 100 Each 6.0000

1 Shp 12-05-17

Rib

Location	Loc Qty	Loc Code
WA	5	
78327	5	
WA005	1	
69730	1	B82969

D4277-3 Manufactured No 100 Each 0.0000

1 B82627 -> 12-05-17

Rib

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Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 83953

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Parent Item Name: Basket Base Assembly, RH

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

D4277-5	Manufactured	No	100	Each	0.0000
Rib					
D4277-9	Manufactured	No	100	Each	0.0000
Rib					
D4277-19	Manufactured	No	100	Each	0.0000
Rib					
D4278-041	Manufactured	No	100	Each	1.0000
Upper Rib Assembly-Hoop					

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	1	
80603	1	

D4278-045	Manufactured	No	100	Each	0.0000
Rib Assembly, Fwd Cham					
D4278-047	Manufactured	No	100	Each	2.0000
Upper Rib Assembly-Straight					

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	2	
80600	2	

D4306-1	Manufactured	No	100	Each	3.0000
Rib					

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	2	
81040	2	
WA006	1	
74278	1	

D4306-044	Manufactured	No	100	Each	0.0000
Rib Assembly, RH					
D4306-045	Manufactured	No	100	Each	4.0000
Rib Assembly					

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA006	4	
72323	4	

~~B82629~~ → ② PC 12.05.02
~~B82626~~ → ① PC 12.05.02
~~B82634~~ → ① PC 12.05.02
~~B4572~~
~~B80750~~ → PC 12.05.02
~~B4572~~ → ①
~~B80750~~ → ② SAA 2 12-05-17
~~SAA~~ 1 12-05-17
~~①~~
~~SAA~~ 1 12-05-17
~~①~~
~~B72902~~ → ① PC 12.05.02
~~SAA~~ 1 12-05-17
~~1~~

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Work Order ID: 83953

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2581
Mounting Bracket

Manufactured No 100 Each 88.0000

2 SAD 12-05-17

Location	Loc Qty	Loc Code
WA	5	
82506	5	
WA005	83	
70766	2	
81253	1	
82017	40	
82897	40	

D3913-15
Wide Handle Plate

Manufactured No 100 Each 19.0000

1 SAD 12-05-17

Location	Loc Qty	Loc Code
WA	7	
81440	6	
82510	1	
WA005	12	
82919	12	

D4016-1
Hinge Half, Base

Manufactured No 100 Each 20.0000

3 ① 3

Location	Loc Qty	Loc Code
WA	20	
66418	0	
82709	12	
82967	8	

③

84049

Pl 12-05-22

Monday, April 30, 2012 10:59:37 AM

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 83953

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1
Handle Plate

Manufactured No

100 Each 30.0000

3

SAD 11-05-17

Location

Loc Qty

Loc Code

WA

14

69518

0

74316

0

74946

0

81181

4

82509

10

WA005

16

82973

16

3

D4279-3

Mesh, Chamfer

Manufactured

No

100 Each 0.0000

1

1

Pl 12-05-22

D4279-5

End Mesh, Basket

Manufactured

No

100 Each 2.0000

1

1

B82632 -> 1 Pl 12-05-22

Location

Loc Qty

Loc Code

WA035

2

73270

2

D4279-7

End Mesh, Basket

Manufactured

No

100 Each 0.0000

2

2

B84128 -> 2 Pl 12-05-22

D4279-9

End Mesh, Basket

Manufactured

No

100 Each 3.0000

1

1

Pl 12-05-22

Location

Loc Qty

Loc Code

WA035

3

73265

3

D4279-11

Mesh, Base

Manufactured

No

100 Each 0.0000

1

1

B80605 -> 1 Pl 12-05-22

Monday, April 30, 2012 10:59:38 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

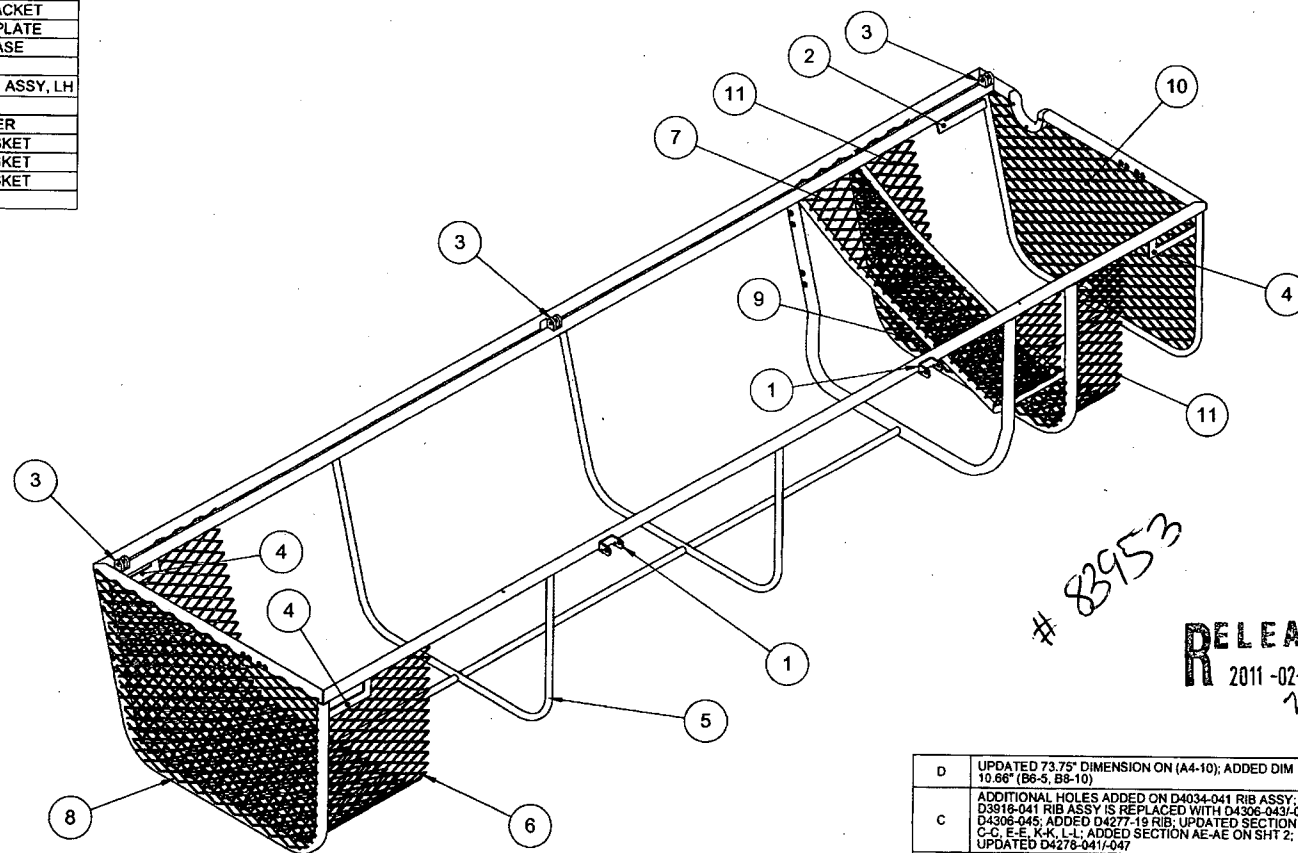
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY; D3918-041 RIB ASSY IS REPLACED WITH D4306-043/044 & D4306-045; ADDED D4277-19 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L, ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041/047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-9); RMV D4277-17, D4278-043 (SHT 4, 9); ADD (1) D3918-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

RELEASED
2011-02-24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4273** REV. D
SHEET 1 OF 10
TITLE **BASKET BASE ASSY** SCALE NTS

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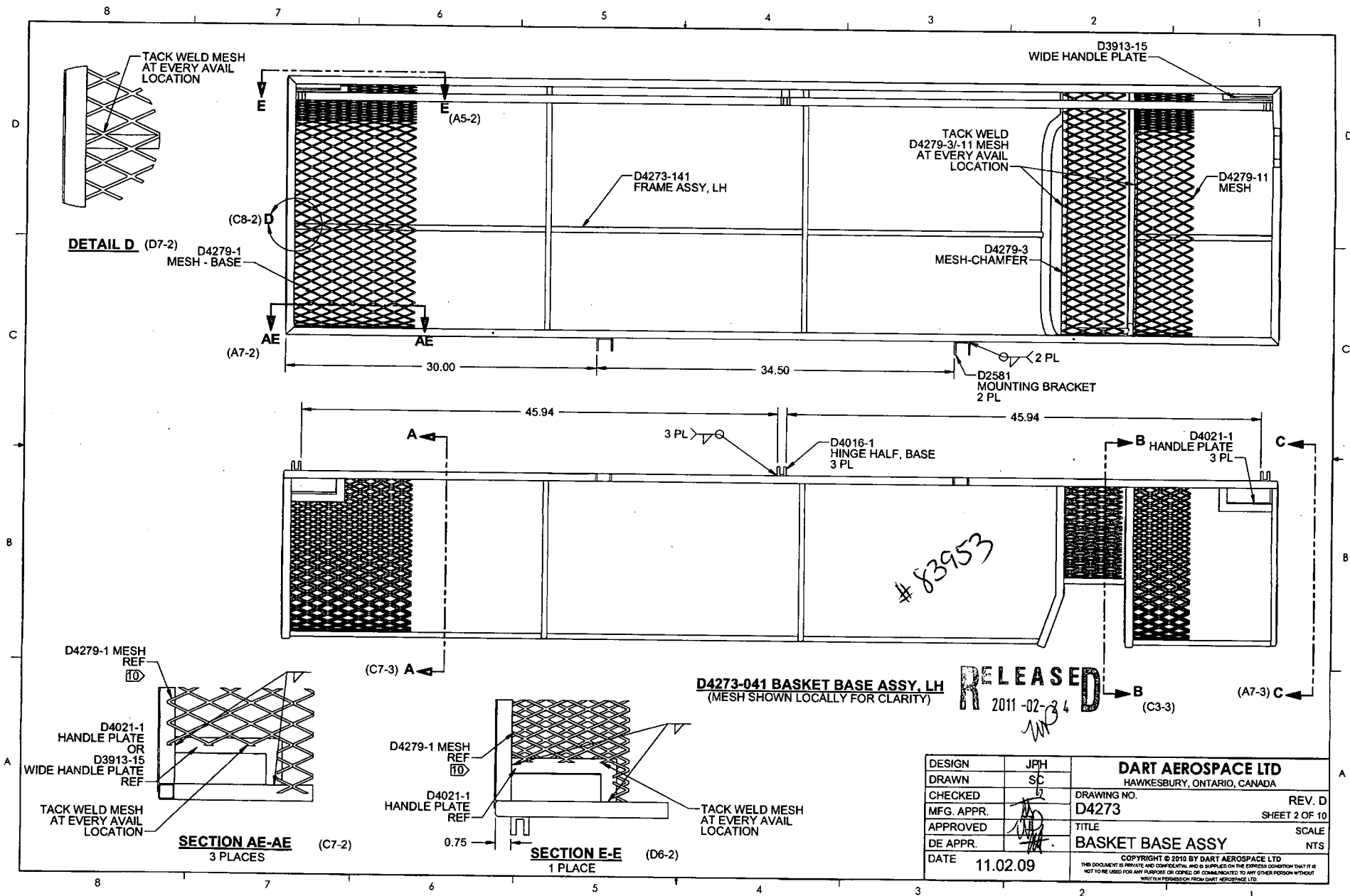
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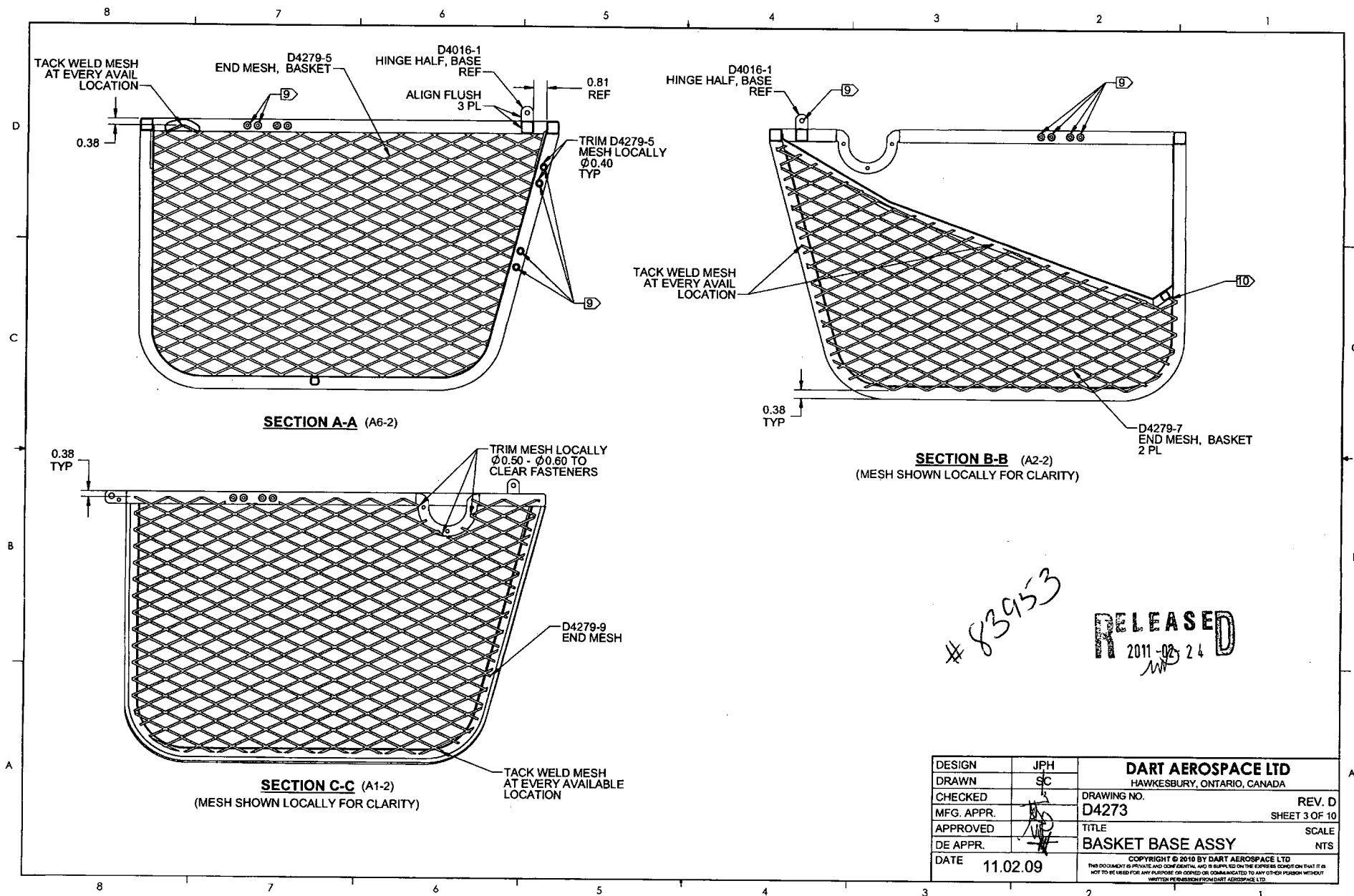
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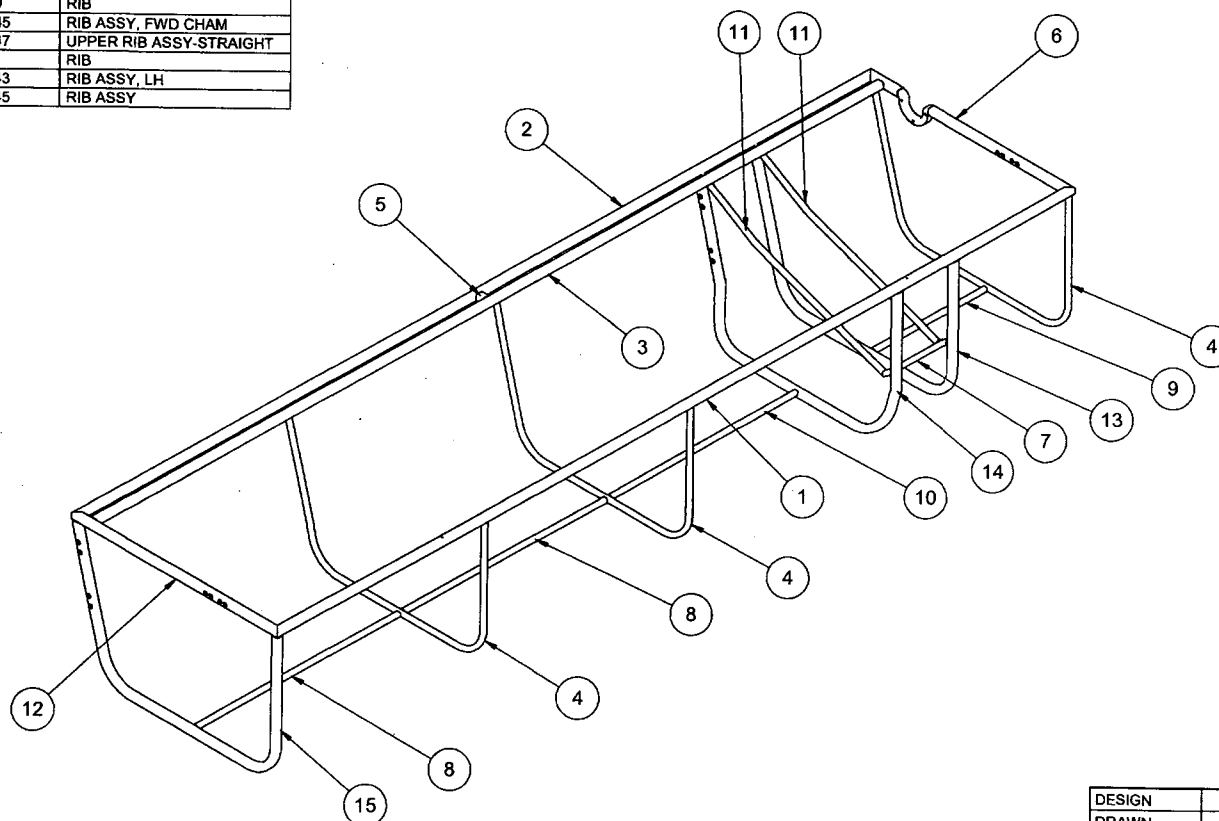
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY



* 83953

RELEASED
2011-02-21
MD

D4273-141 FRAME ASSY, LH

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4273
MFG. APPR.		REV. D SHEET 4 OF 10
APPROVED		TITLE BASKET BASE ASSY
DE APPR.		SCALE NTS
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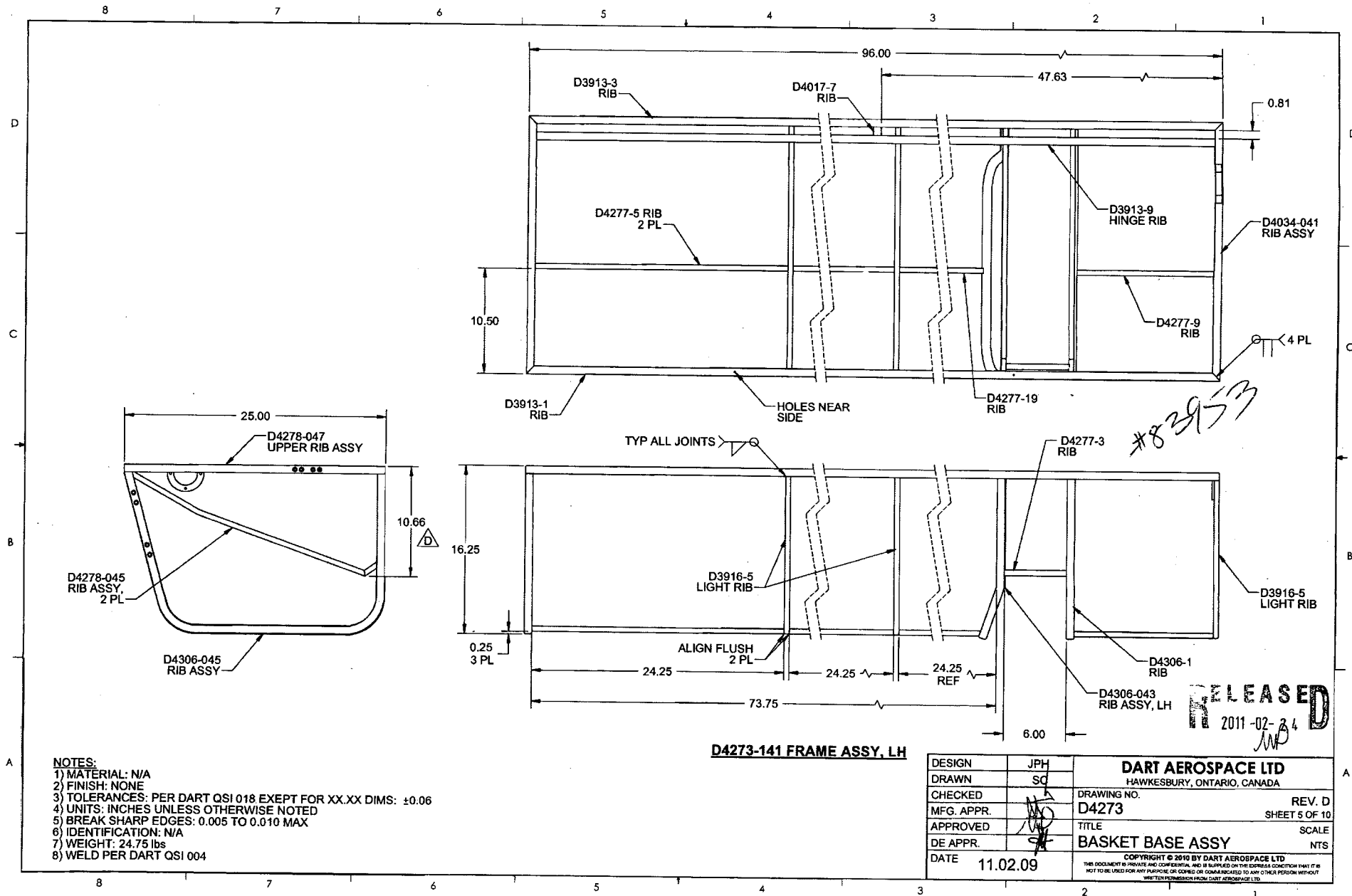
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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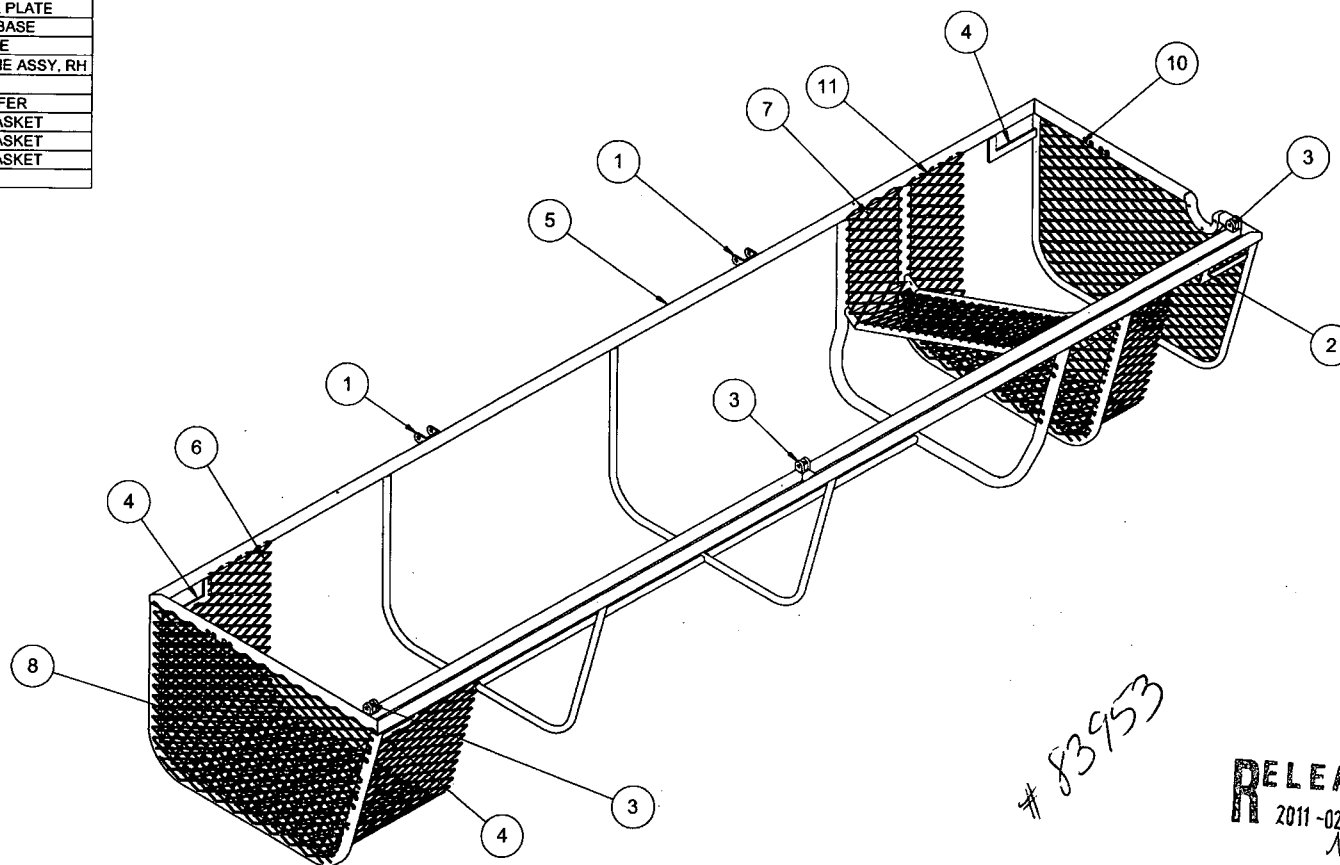
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

83953

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D4273	SHEET 6 OF 10
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	BASKET BASE ASSY	NTS
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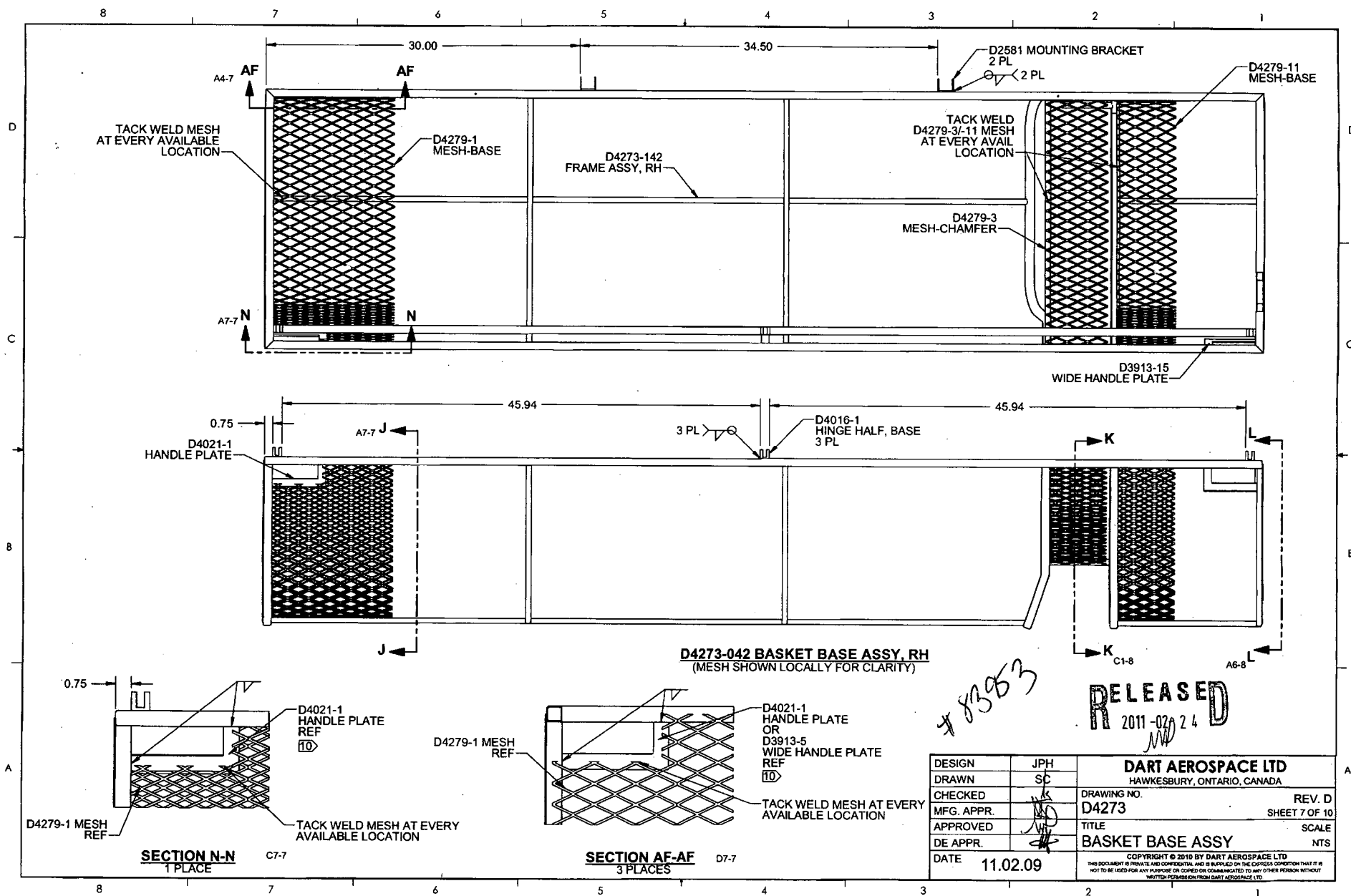
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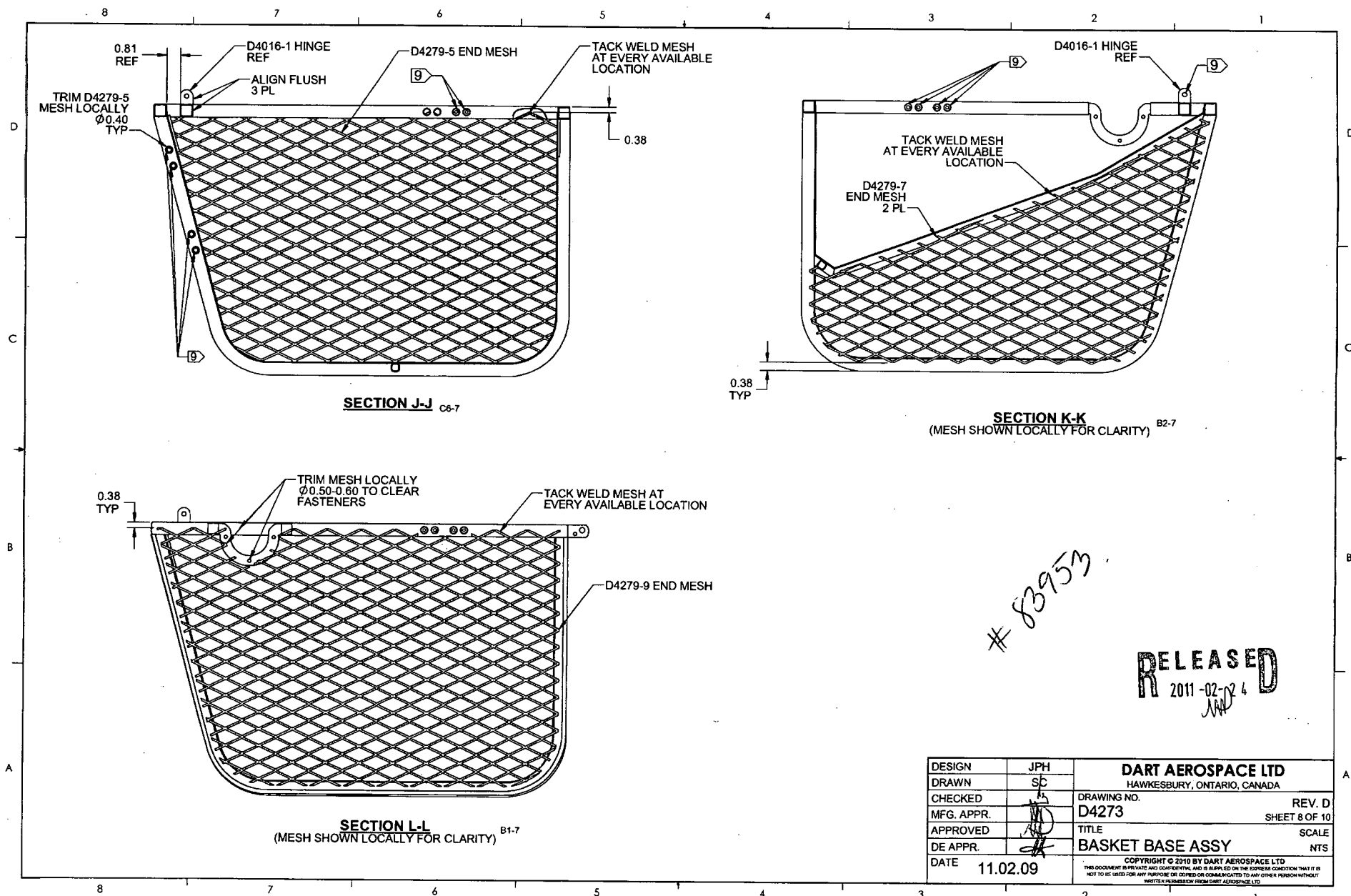
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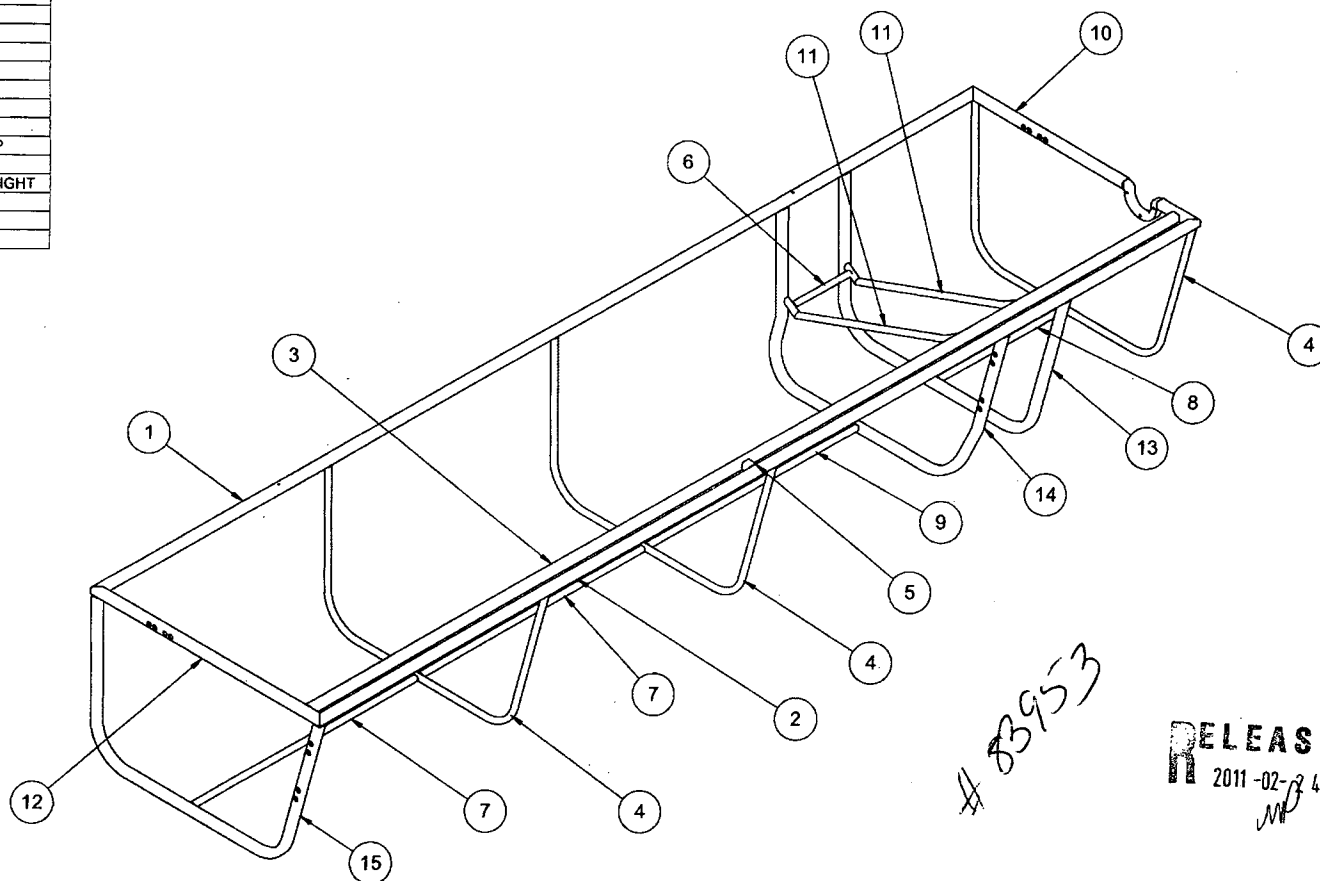
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY



D4273-142 BASKET FRAME ASSY, RH

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CHECKED	AS	DRAWING NO.	REV. D
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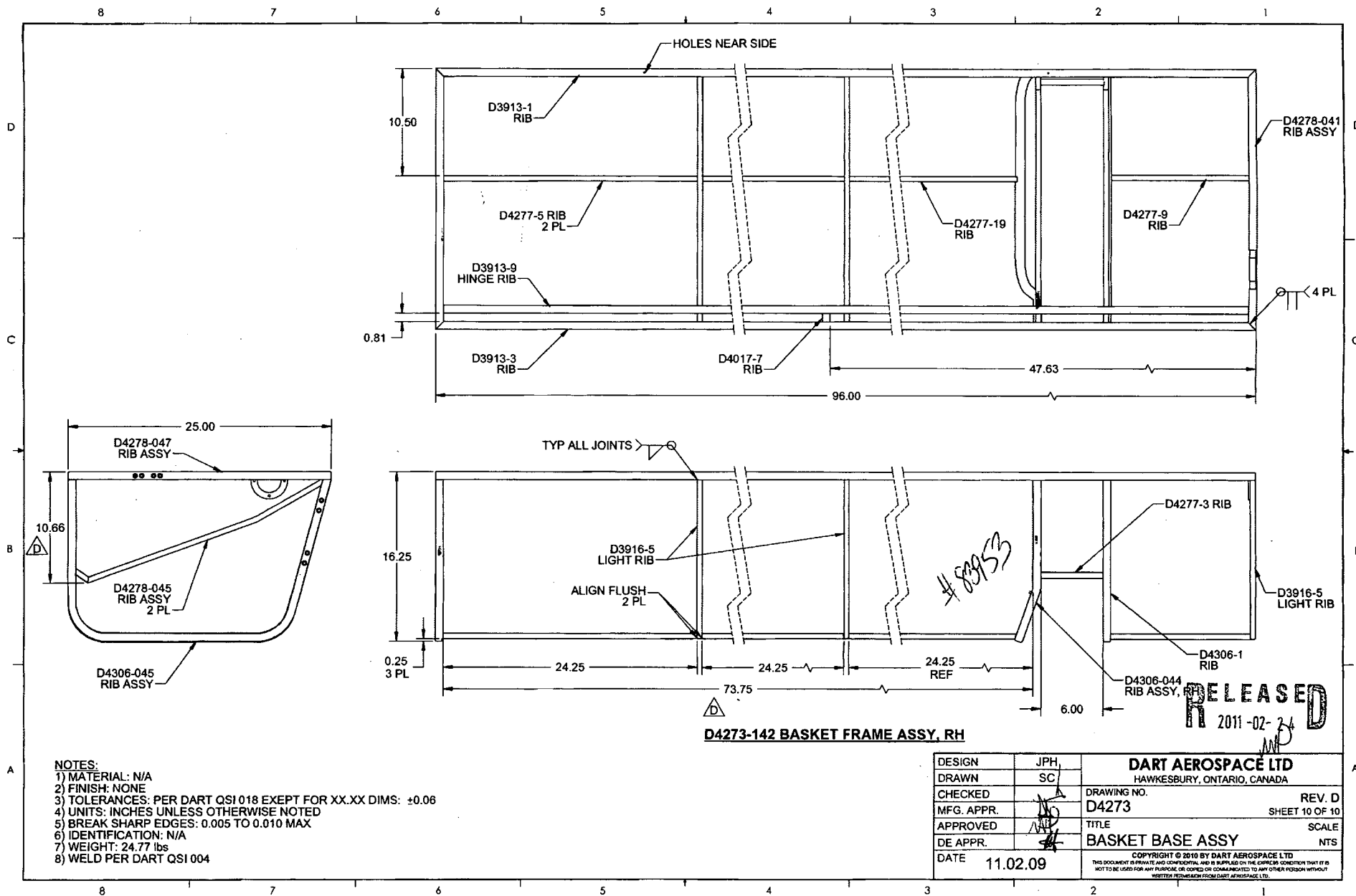
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